

Date: Monday, 6/26/2006 3:46:14 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	D119 HELI UTILITY BASKET
Job Number :	27693	Part Number :	D119756041
Estimate Number :	12452	Drawing Number :	IIN D119-756 PREL
P.O. Number :	N/A	Project Number :	N/A
This Issue :	6/26/2006	Drawing Revision :	PREL
Prsht Rev. :	NC	Material :	N/A
First Issue :	N/A	Due Date :	7/3/2006
Previous Run :	N/A	Qty:	1 Um: Each
Written By :	SRE (COMMENT BELOW)		
Checked & Approved By :	JF 06.06.26.2		
Comment :	Est Rev:A New Issue 06-06-14 JLM		

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	27693A	BASKET LID ASS'Y (A119)
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Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT

2.0	27693B	BASKET BASE ASS'Y (A119)
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Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT

3.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 001

N/A

4.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: B 25815

5.0	D2258220	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B 27580 B11837

6.0	D2332041	Lid Prop Assembly 6.69"
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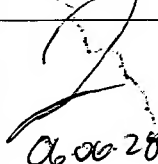
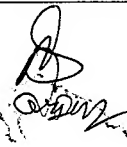
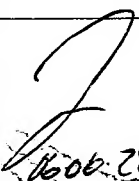


Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: 26880

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/04/28	5.	D 2258-200 was to be instead D2258- 220.		Scrap + destroy	SAD 06.06.28	 06.06.28		 06.06.28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06.07.20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: . Monday, 6/26/2006 3:46:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET

Job Number: 27693

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

7.0	D2530	Handle Weldment
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: B 26406

8.0	D2535	Spring
-----	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: B 24532

9.0	D2537	Bushing
-----	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: B 26468

10.0	D2931	Bumper
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: B 91139

11.0	AN316A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M 100564

12.0	AN47A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M 19278

13.0	AN422A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M 18822

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/26/2006 3:46:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET

Job Number: 27693

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: m 17204

15.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: m 100771

16.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: m 101369

17.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) + 2.0000

Washer

Batch: m 101237

06.06.20

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: m 19185

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: m 11989

20.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: m 100151

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/26/2006 3:46:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET

Job Number: 27693

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: B 13767

22.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: B 100393

23.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: B 19085

24.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: B 17694

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D119-756

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

15T
pg
P10

HM 06-06-28

SB 04/06/28

160628

P.D.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/26/2006 3:46:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET

Job Number: 27693

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D119756011

CLAMP KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
CLAMP KIT
Batch: ~~27711~~ 27711

See Attached Kit

29.0

D35171

STRUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
STRUT
Batch: ~~322695~~ 322695

30.0

D3518041

FWD ARM ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
FWD ARM ASSEMBLY
Batch: ~~20695~~ 20695

31.0

D35191

placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
placard
Batch: N/A

06.06.28 Part not ready yet, will bring with me to Philadelphia.

32.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bolt
Batch: M101291 ✓

06.06.28

33.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bolt
Batch: M101149 ✓

06.06.28

34.0

AN415A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)
Bolt
Batch: M19085 ✓

06.06.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/26/2006 3:46:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET

Job Number: 27693

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Washer

Batch: M101369 ✓

30.

306.06.28

36.0

AN960JD416L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

BATCH: M14237 ✓

306.06.28

37.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nut

Batch: M1085 ✓

12

306.06.28

PLC/c/28

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

See Attached
08-04-15

06/06/28

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119

Location:

PPP Rev: DMP

06/06/28 (1)

40.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.20

Job Completion



chg'd to w/o 048A

06-07-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart *Heli-Utility-Basket™* which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.

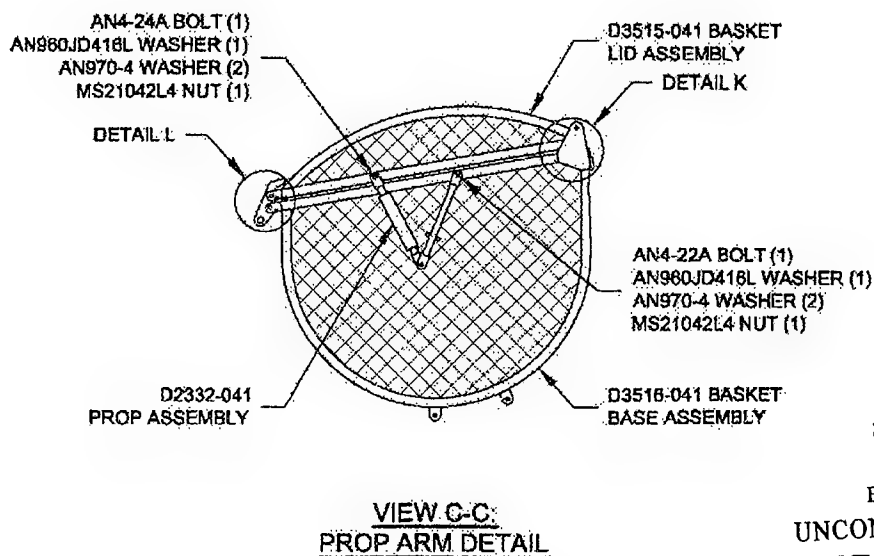
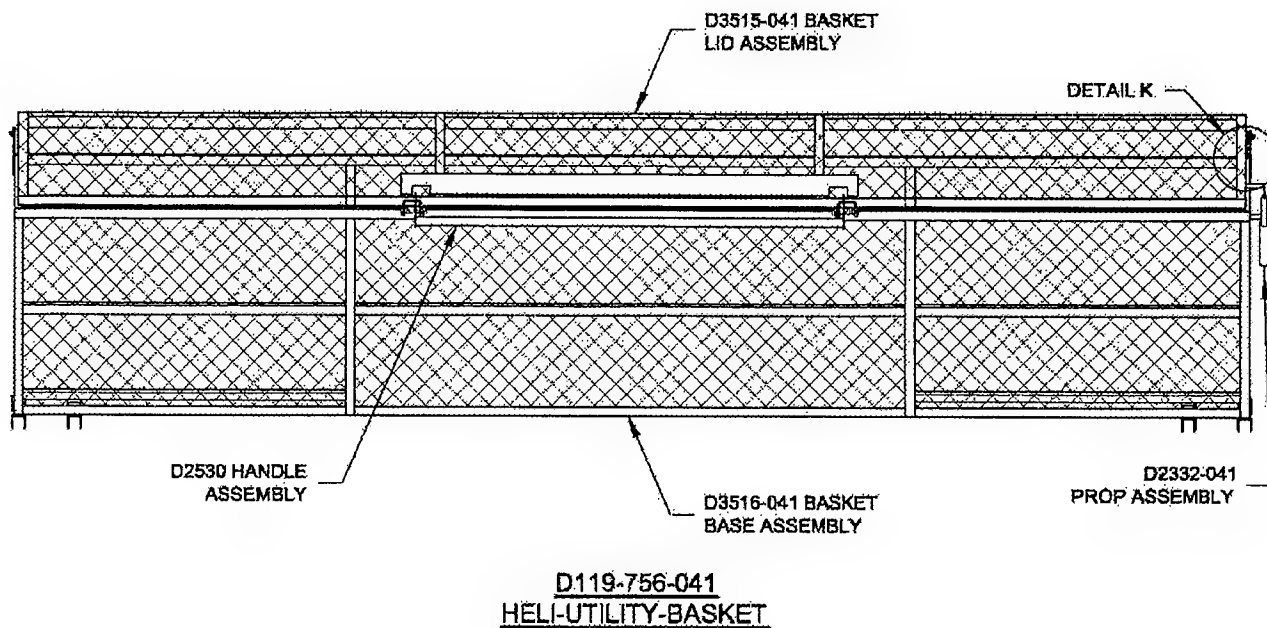


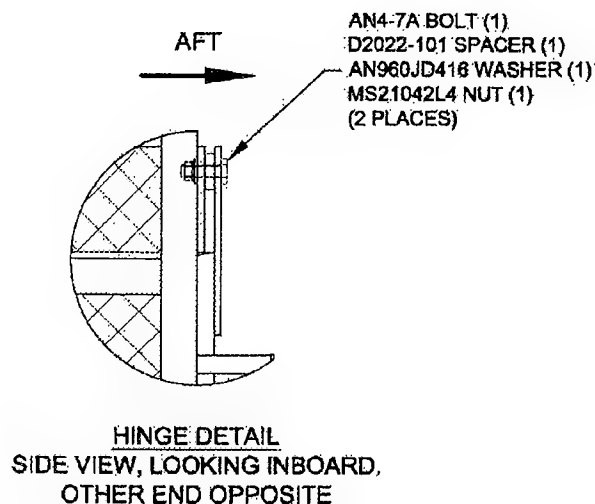
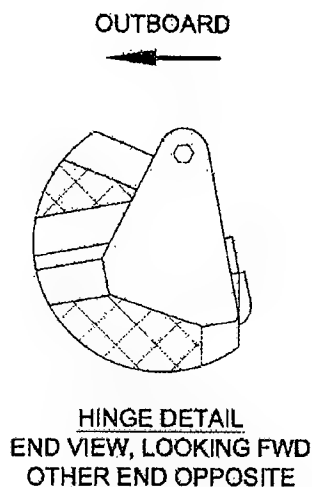
Figure 4 – Basket Replacement Parts
(D119-756-041 Heli-Utility-Basket™)

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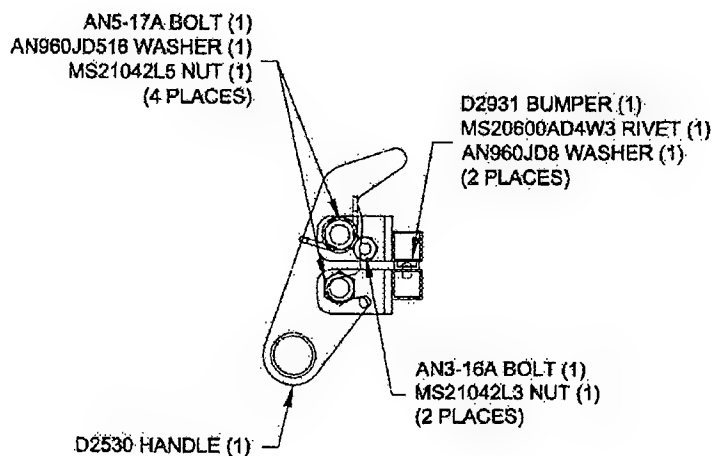
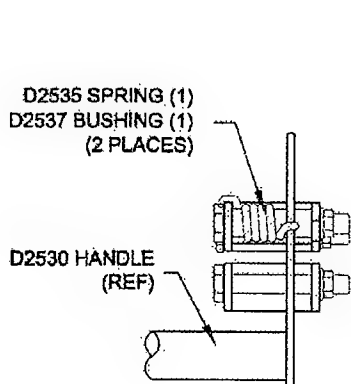
**PROTOTYPE
PRELIMINARY ISSUE**

STAMP COPY
RE
ENGIN
UNCONTROL
SUBJECT TO A
WITHOUT N
WORK ORD
NO. **27693**

Revision: **A**
Date: 06.06.22



DETAIL K: HINGE



DETAIL L: HANDLE WELDMENT

Figure 5 – Basket Replacement Parts
(D119-756-041 Heli-Utility-Basket™)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED &
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27693

Date: Tuesday, 15/04/2008 11:35:43 AM
 User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 27693	Customer	: Dart Helicopters Services
Estimate Number	: 12452	DWG Name	: D119 HELI UTILITY BASKET
Purchase Order #	:	Part Number	: D119756041
Complete Date	: 17/07/2006 11:38:44	DWG Number	: IIN D119-756 PREL
		Rev.	: PREL

DUE DATE	ORDERED	DELIVERED
03/07/2006	1	1

1.0 D3515041-Basket Lid Assembly	SUB-Component/Sub-job					
DATE	EMPLOYEE	TYPE	Qty			
17/07/2006	LACE01: Lacelle, Linda		1.000		\$579.72	27693A
Subtotal:	CTD:	0			\$579.72	

2.0 D3516041-Basket Base Assembly (A119)	SUB-Component/					
DATE	EMPLOYEE	TYPE	Qty			
17/07/2006	LACE01: Lacelle, Linda		1.000		\$688.09	27693B
Subtotal:	CTD:	0			\$688.09	

4.0 D2022101-Spacer	INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	D2022101	2.000		\$4.91	Lot # 25815 Qty. 2
Subtotal:	QTD:	2	CTD:	0	\$4.91	

5.0 D2258220-Placard	INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	D2258220	1.000		\$5.94	Lot # 11837 Qty. 1
Subtotal:	QTD:	1	CTD:	0	\$5.94	

6.0 D2332041-Lid Prop Assembly 6.69" long	INVENTORY ITE					
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	D2332041	1.000		\$40.66	Lot # 26880 Qty. 1
Subtotal:	QTD:	1	CTD:	0	\$40.66	

7.0 D2530-Handle Weldment	INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	D2530	1.000		\$39.37	Lot # 26406 Qty. 1
Subtotal:	QTD:	1	CTD:	0	\$39.37	

8.0 D2535-Spring	INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	D2535	2.000		\$3.91	Lot # 24532 Qty. 2
Subtotal:	QTD:	2	CTD:	0	\$3.91	

9.0 D2537-Bushing	INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	D2537	2.000		\$26.29	Lot # 26468 Qty. 2
Subtotal:	QTD:	2	CTD:	0	\$26.29	

10.0 D2931-Bumper	INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	D2931	2.000		\$0.12	Lot # 21139 Qty. 2
Subtotal:	QTD:	2	CTD:	0	\$0.12	

Date: Tuesday, 15/04/2008 11:35:43 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 27693	Customer	: Dart Helicopters Services
Estimate Number	: 12452	DWG Name	: D119 HELI UTILITY BASKET
Purchase Order #	:	Part Number	: D119756041
Complete Date	: 17/07/2006 11:38:44	DWG Number	: IIN D119-756 PREL
		Rev.	: PREL

11.0 AN316A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN316A	2.000		\$0.61	Lot # 100564 Qty. 2
Subtotal:		QTD:	2	CTD:	0	\$0.61

12.0 AN47A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN47A	2.000		\$0.24	Lot # 19278 Qty. 2
Subtotal:		QTD:	2	CTD:	0	\$0.24

13.0 AN422A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN422A	1.000		\$0.32	Lot # 18822 Qty. 1
Subtotal:		QTD:	1	CTD:	0	\$0.32

14.0 AN424A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN424A	1.000		\$0.36	Lot # 17204 Qty. 1
Subtotal:		QTD:	1	CTD:	0	\$0.36

15.0 AN517A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN517A	4.000		\$1.60	Lot # 100771 Qty. 4
Subtotal:		QTD:	4	CTD:	0	\$1.60

16.0 AN960JD416-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN960JD416	2.000		\$0.07	Lot # 101369 Qty. 2
Subtotal:		QTD:	2	CTD:	0	\$0.07

17.0 AN960JD416L-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN960JD416L	4.000		\$0.24	Lot # 101237 Qty. 4
Subtotal:		QTD:	4	CTD:	0	\$0.24

18.0 AN960JD516-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN960JD516	4.000		\$0.21	Lot # 19185 Qty. 4
Subtotal:		QTD:	4	CTD:	0	\$0.21

19.0 AN960JD8-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN960JD8	2.000		\$0.04	Lot # 11989 Qty. 2
Subtotal:		QTD:	2	CTD:	0	\$0.04

Date: Tuesday, 15/04/2008 11:35:44 AM
 User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 27693	Customer	: Dart Helicopters Services
Estimate Number	: 12452	DWG Name	: D119 HELI UTILITY BASKET
Purchase Order #	:	Part Number	: D119756041
Complete Date	: 17/07/2006 11:38:44	DWG Number	: IIN D119-756 PREL
		Rev.	: PREL

20.0 AN9704-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN9704	4.000		\$0.41	Lot # 100151 Qty. 4
Subtotal:		QTD:	4	CTD:	0	\$0.41

21.0 MS20600AD4W3-Cherry Rivets INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	MS20600AD4W3	2.000		\$0.27	Lot # 13767 Qty. 2
Subtotal:		QTD:	2	CTD:	0	\$0.27

22.0 MS21042L3-Nut INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	MS21042L3	2.000		\$0.21	Lot # 100393 Qty. 2
Subtotal:		QTD:	2	CTD:	0	\$0.21

23.0 MS21042L4-Nut INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	MS21042L4	4.000		\$0.24	Lot # 19085 Qty. 4
Subtotal:		QTD:	4	CTD:	0	\$0.24

24.0 MS21042L5-Nut INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	MS21042L5	4.000		\$1.23	Lot # 17694 Qty. 4
Subtotal:		QTD:	4	CTD:	0	\$1.23

25.0 SMALL FAB 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
28/06/2006	MBON01: MBonde, Hermine	Run	0.000	2.22	\$22.20	4.16	0.00	
28/06/2006	DROU02: Drouin, Steven	Run	0.000	1.25	\$17.19	1.25	0.00	
Subtotal:		QTD:	0	CTD:	0	3.47	\$39.39	

28.0 D119756011-Clamp INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	D119756011	1.000		\$204.79	Lot # 27719 Qty. 1
15/04/2008	LACE01: Lacelle, Linda	D119756011	1.000		\$148.32	Lot # 37599 Qty. 1
Subtotal:		QTD:	1	CTD:	1	\$353.11

29.0 D119756013-Quick Release INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/04/2008	LACE01: Lacelle, Linda	D119756013	1.000		\$70.02	Lot # 31580 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$70.02

30.0 D26173-Bushing INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
15/04/2008	LACE01: Lacelle, Linda	D26173	2.000		\$4.41	Lot # 29991 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$4.41

Date: Tuesday, 15/04/2008 11:35:44 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 27693	Customer	: Dart Helicopters Services
Estimate Number	: 12452	DWG Name	: D119 HELI UTILITY BASKET
Purchase Order #	:	Part Number	: D119756041
Complete Date	: 17/07/2006 11:38:44	DWG Number	: IIN D119-756 PREL
		Rev.	: PREL

31.0 D26175-Spacer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/04/2008	LACE01: Lacelle, Linda	D26175	4.000		\$10.01	Lot # 35977 Qty. 4
Subtotal:			QTD: 0	CTD: 4	\$10.01	

32.0 D351611-Clevis INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/04/2008	LACE01: Lacelle, Linda	D351611	2.000		\$10.61	Lot # 37619 Qty. 2
Subtotal:			QTD: 0	CTD: 2	\$10.61	

33.0 D35171-Strut INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	D35171	2.000		\$472.72	Lot # 27694 Qty. 2
15/04/2008	LACE01: Lacelle, Linda	D35171	2.000		\$61.68	Lot # 31802 Qty. 2
Subtotal:			QTD: 2	CTD: 2	\$534.40	

34.0 D3518041-Strut Assembly INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	D3518041	2.000		\$738.71	838604 Qty. 2 Lot # 27695 Qty. 2
Subtotal:			QTD: 2	CTD: 0	\$738.71	

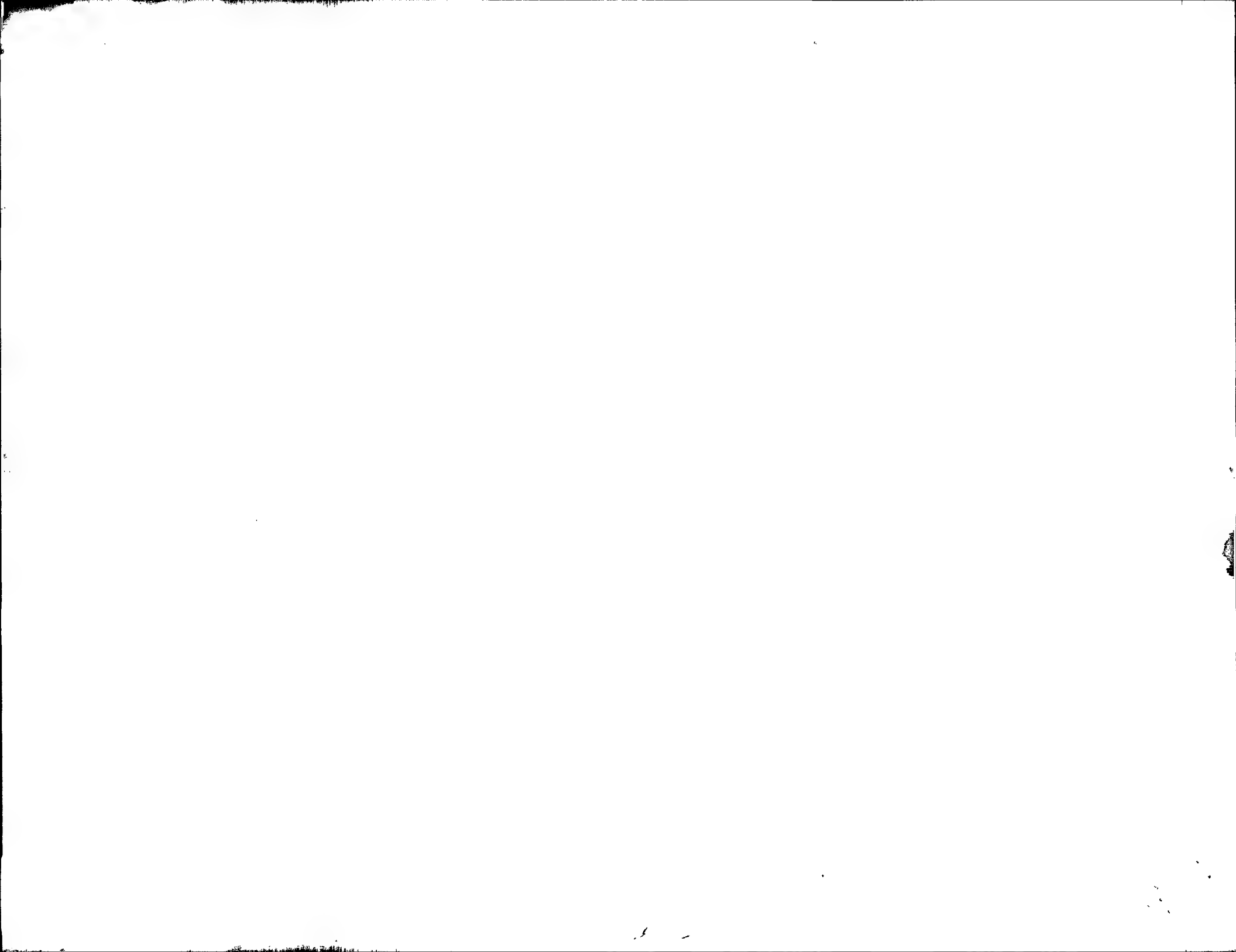
35.0 D35201-Spacer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/04/2008	LACE01: Lacelle, Linda	D35201	2.000		\$45.96	Lot # 37623 Qty. 2
Subtotal:			QTD: 0	CTD: 2	\$45.96	

37.0 AN412A-Bolt INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN412A	4.000		\$0.86	Lot # 101291 Qty. 4
Subtotal:			QTD: 4	CTD: 0	\$0.86	

38.0 AN413A-Bolt INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN413A	4.000		\$0.67	Lot # 101149 Qty. 4
15/04/2008	LACE01: Lacelle, Linda	AN413A	2.000		\$0.55	Lot # 107321 Qty. 2
Subtotal:			QTD: 4	CTD: 2	\$1.22	

39.0 AN415A-Bolt INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
17/07/2006	LACE01: Lacelle, Linda	AN415A	12.000		\$2.35	Lot # 19085 Qty. 12
15/04/2008	LACE01: Lacelle, Linda	AN415A	6.000		\$1.19	Lot # 107321 Qty. 6
Subtotal:			QTD: 12	CTD: 6	\$3.54	

40.0 AN420A-Bolt INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
15/04/2008	LACE01: Lacelle, Linda	AN420A	2.000		\$0.53	Lot # 16895 Qty. 2
Subtotal:			QTD: 0	CTD: 2	\$0.53	



Date: Tuesday, 15/04/2008 11:35:44 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 27693	Customer	: Dart Helicopters Services
Estimate Number	: 12452	DWG Name	: D119 HELI UTILITY BASKET
Purchase Order #	:	Part Number	: D119756041
Complete Date	: 17/07/2006 11:38:44	DWG Number	: IIN D119-756 PREL
		Rev.	: PREL

41.0 AN510A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/04/2008	LACE01: Lacelle, Linda	AN510A	2.000	\$0.54	Lot # 107013 Qty. 2

Subtotal: QTD: 0 CTD: 2 \$0.54

42.0 AN960JD416-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
17/07/2006	LACE01: Lacelle, Linda	AN960JD416	30.000	\$1.01	Lot # 101369 Qty. 30
15/04/2008	LACE01: Lacelle, Linda	AN960JD416	40.000	\$1.18	Lot # 106780 Qty. 40

Subtotal: QTD: 30 CTD: 40 \$2.19

43.0 AN960JD416L-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/04/2008	LACE01: Lacelle, Linda	AN960JD416L	4.000	\$0.26	Lot # 107008 Qty. 4

Subtotal: QTD: 0 CTD: 4 \$0.26

44.0 AN960JD516L-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
15/04/2008	LACE01: Lacelle, Linda	AN960JD516L	2.000	\$0.12	Lot # 17619 Qty. 2

Subtotal: QTD: 0 CTD: 2 \$0.12

45.0 MS21042L4-Nut INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
17/07/2006	LACE01: Lacelle, Linda	MS21042L4	12.000	\$0.73	Lot # 19085 Qty. 12
15/04/2008	LACE01: Lacelle, Linda	MS21042L4	10.000	\$1.62	Lot # 106825 Qty. 10

Subtotal: QTD: 12 CTD: 10 \$2.35

		TIME	COST
	Machine Time:	5.41	\$0.00
	Labor:	3.47	\$39.39
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$1906.09
	SUB-COMPONENT (SUB-JOB):		\$1267.81
Total:			\$3213.29

COST PER UNIT: \$3213.29

OK 4 17-04-15

7.0 PARTS LIST

Qty-041	Qty-011	Qty-013	Part Number	Description
X			D119-756-041	HELI-UTILITY-BASKET™
X	X		D119-756-011	CLAMP KIT
		X	D119-756-013	QUICK RELEASE KIT
2			D2022-101	* SPACER
1			D2258-220	* PLACARD
1			D2332-041	* PROP ASSEMBLY
1			D2530	* HANDLE ASSEMBLY
2			D2535	* SPRING
2			D2537	* BUSHING
2	2		D2617-3	BUSHING
4	4		D2617-5	BUSHING
	4		D2732-032	RUBBER CUSHION
	2		D2856-200-766	ABRASION STRIP
2			D2931	* BUMPER
	1		D3041-1	CLAMP
	1		D3041-3	CLAMP
	1		D3041-5	CLAMP
	1		D3041-7	CLAMP
1			D3515-041	* BASKET LID ASSEMBLY
1			D3516-041	* BASKET BASE ASSEMBLY
2			D3516-11	CLEVIS
2			D3517-1	* STRUT
2			D3518-041	* STRUT ASSEMBLY
2			D3519-1	* PLACARD
2			D3520-1	SPACER
2			AN3-16A	* BOLT
2			AN4-7A	* BOLT
2			AN4-13A	BOLT
6			AN4-15A	BOLT
	2		AN4-17A	BOLT
2	2		AN4-20A	BOLT
1			AN4-22A	* BOLT
1			AN4-24A	* BOLT
2			AN5-10A	BOLT
4			AN5-17A	* BOLT
2			AN960JD416	* WASHER
40	4		AN960JD416	WASHER
2			AN960JD416L	* WASHER
4			AN960JD416L	WASHER
4			AN960JD516	* WASHER
2			AN960JD516L	WASHER
2			AN960JD8	* WASHER
4			AN970-4	* WASHER
		4	BLRS-020	POSITIVE LOCKING QUICK RELEASE PIN
2			MS20600AD4W3	* RIVET
2			MS21042L3	* NUT (OR MS21042-3)
4			MS21042L4	* NUT (OR MS21042-4)
10	4		MS21042L4	NUT (OR MS21042-4)
4			MS21042L5	* NUT (OR MS21042-5)

* indicates that part is pre-assembled on basket for customer

X-VERIFY CONDITION

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Revision: C

Date: 06.10.23

L Lacelle

From: mbellavance@dartaero.com
Sent: April 15, 2008 8:35 AM
To: mpetsche@dartaero.com
Cc: llacelle@dartaero.com
Subject: MB sick

Mornin Mike,

I was not feeling top shape yesterday and I now have a fever with killing headache. Sorry but I won't be in today.

Linda will most likely ask for A119 basket stuff.

The B/N of the basket should be found on the red label, inside the basket lid.

Also, I have prepared a list and it's on my desk.

What we need to include in the shipment shows in green.

For parts that can't be found in store: I'm sure Dan S. and/or Russ can scavenge those in the Eng. Lab Mezzanine.

See ya'll tomorrow...

Marc

Date: Tuesday, 15/04/2008 10:44:48 AM
 *User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET (A119) ARMS
Job Number :	38604		
Estimate Number :	12443		
P.O. Number :		Part Number :	D3518041
This Issue :	15/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3518 REV.B
First Issue :	1/1	Project Number :	N/A
Previous Run :	37621	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/04/2008
Written By :		Qty:	2
Checked & Approved By :		Um:	Each
Comment :	EST rev. A 05.06.06 preliminary EC		
	est rev b 06.07.31 re-design EC		
	est rev C 07.04.09 revB dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D23245	Strap
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Strap batch: B 36749 ① B 37631 ③ SB 08/04/15 ②		
2.0	D35181	Strut
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) FWD ARM Batch: B 31683 SB 08/04/15 ②		
3.0	D35183	Stainless Steel Ball Joint Rod End
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) AFT ARM Batch: B 37641 SB 08/04/15 ②		
4.0	AN313A	Bolt
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Bolt Batch: M 104748 SB 08/04/15 ②		
5.0	AN316C6R	Nut
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Nut batch: M 102809 SB 08/04/15 ②		

Date: Tuesday, 15/04/2008 10:44:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) ARMS

Job Number: 38604

Part Number: D3518041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M 107 534

SA 08/04/15 (2)

7.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M 106 883

SA 08/04/15 (2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3518

ml 08/04/15 x2

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 08/04/15 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Part # D3518-041 using fine point permanent ink marker and Stock

Location: _____

SA 08/04/15 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



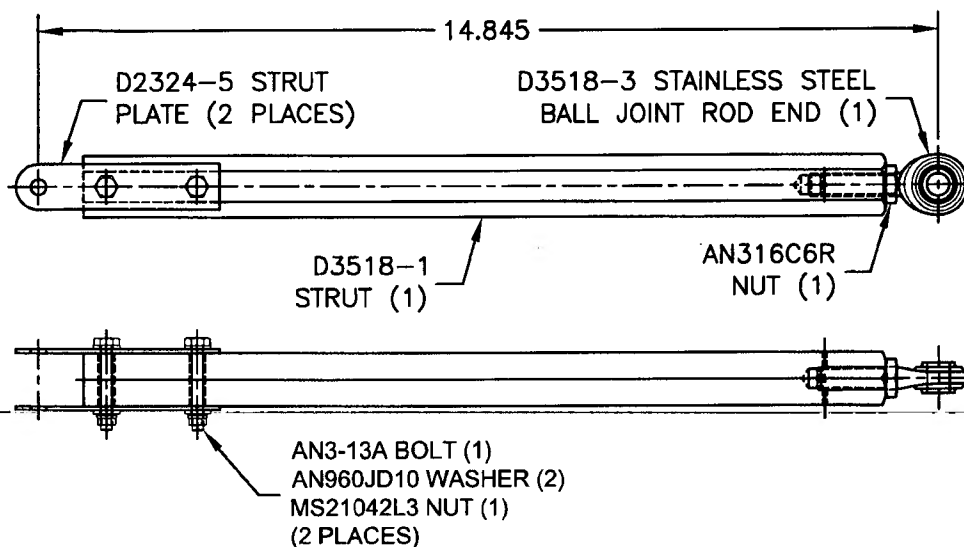
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 1 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3
A	06.06.21	NEW ISSUE	
B	06.10.23	RE-DESIGN	



D3518-041 STRUT ASSEMBLY

QTY -041	Part Number	Description
X	D3518-041	STRUT ASSEMBLY
2	D2324-5	STRUT PLATE
1	D3518-1	STRUT
1	D3518-3	STAINLESS STEEL BALL JOINT ROD END
2	AN3-13A	BOLT
1	AN316C6R	NUT
4	AN960JD10	WASHER
2	MS21042L3	NUT

NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

RELEASED

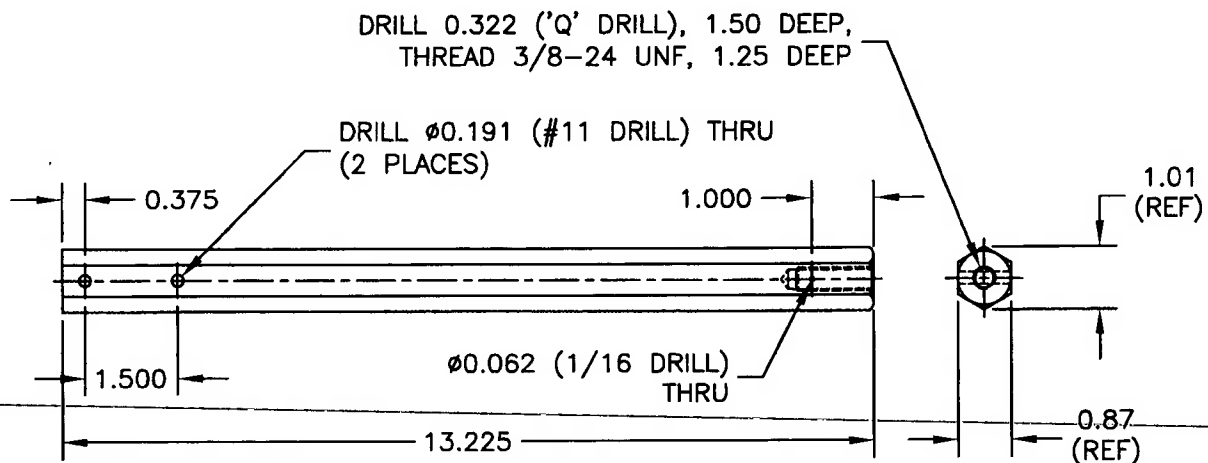
06.11.17 *[Signature]*

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 2 OF 3
DATE 06.10.23	TITLE BASKET (A119) STRUT		SCALE 1:3

**D3518-1 STRUT****NOTES:**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

RELEASED

06.11.17 *[Signature]*

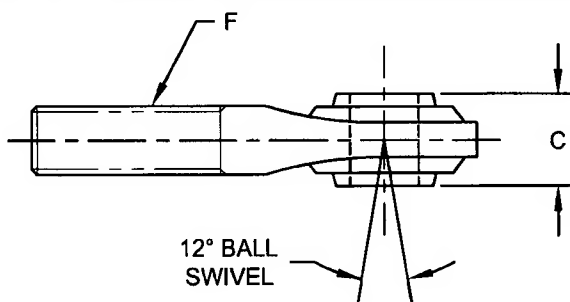
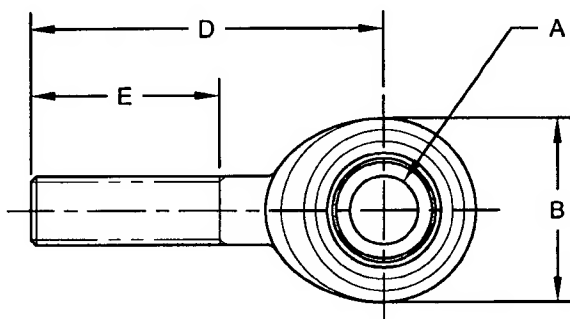
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DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 3 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:1

SPECIFICATION CONTROL DRAWING



DART P/N	A	B	C	D	E	F	LOAD*	POSSIBLE SUPPLIER
D3518-3	0.375	1.00	0.50	1.938	1.25	3/8-24 UNF, RH	4012	McMASTER-CARR, P/N 2458K14

* Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.11.17 *[Signature]*

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